

Work Order ID 137358

September 25, 2015 8:53:12 AM

Need Oct 27

137358

Page 1

Item ID: D4842-041

Revision ID:

Item Name: Lower Cutter Assembly

Start Date: 9/25/2015 Start Qty: 6.00

Required Date: 10/22/2015 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan: S4

Date: 20150925

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4842	REV B								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces.								
	A/R LOCTITE 598: <u>M133436</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
6
NOV 09 2015

EX 15/11/10 36 9-89

⑥ DAS
38
9-89
NOV 13 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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Page 2

Item ID: D4842-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lower Cutter Assembly

Stop

NS2

Start Date: 9/25/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/22/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location *CCK0015* 0.00***140***

Packaging

Memo

0.00

Packaging

*D48
6
989**NOV 12 2015*

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

*MCS 15-11-13**MF
15-11-13*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

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Page 1

Work Order ID: 137358

137358

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 9/25/2015

Required Date: 10/22/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.04.30 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.01 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4839-1 *D4839-1* Blade		Manufactured	No				Each	7.0000		12			DAS 6 9-89
** 137690 X4													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK128			7						
				134649			7						
D4842-1 *D4842-1* Lower Cutter Deflector		Manufactured	No				Each	5.0000		6			DAS 6 9-89
** 137374 X1													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK128			5						
				100670			1						
				107947			3						
				109250			1						
D4842-3 *D4842-3* Lower Cutter Body, LH		Manufactured	No				Each	2.0000		6			DAS 6 9-89
** 137373 X3													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				MF			2						
				107957			2						
D4842-4 *D4842-4* Lower Cutter Body, RH		Manufactured	No				Each	7.0000		6			DAS 6 9-89
** 137372 X4													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK128			7						
				108070			1						
				109252			6						

Picklist Print

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Work Order ID: 137358

137358

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 9/25/2015

Required Date: 10/22/2015

Start Qty: 6.00

Required Qty: 6.00

MS21042L08

Purchased

No

Each

812.0000

36

MS21042L 08

Nut

M135523

DAS

6

9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

300

m133134

300

ST304

411

123900

16

m128401

102

m128429

3

m131317

62

m132930

228

DAS

36

9-89

MS27039-08-19

Purchased

No

Each

562.0000

36

MS27039-08-19

Screw

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

250

m132930

250

ST260a

100

m133077

100

ST273A

183

m131317

183

ST281

29

m131264

29

DAS

36

9-89

NOV 09 2015

Picklist Print

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Work Order ID: 137358

137358

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 9/25/2015

Required Date: 10/22/2015

Start Qty: 6.00

Required Qty: 6.00

NAS1149FN832P

Purchased

No

Each

1,949.000

72

NAS1149FN832P

133284

Washer

Location

Loc Qty

Loc Code

GA

737

125268

737

ST260a

291

125268

291

st268

921

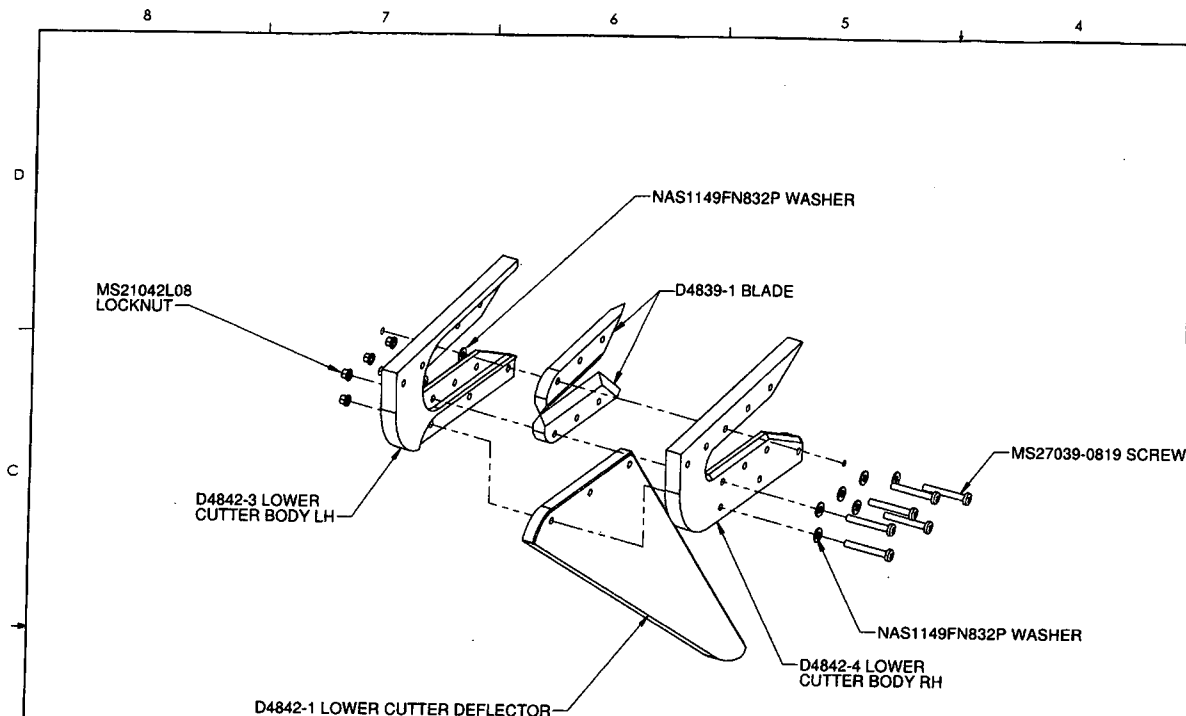
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921

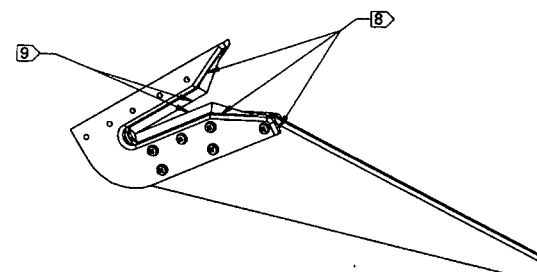
36 ~~70~~ 36 15/11/10
DAS 6
9-89

DAS
6
+00

NOV 09 2015



ITEM	QTY -041	P/N	DESCRIPTION
	X	D4842-041	LOWER CUTTER ASSY
1	2	D4839-1	BLADE
2	1	D4842-1	LOWER CUTTER DEFLECTOR
3	1	D4842-3	LOWER CUTTER BODY LH
4	1	D4842-4	LOWER CUTTER BODY RH
5	6	MS21042L08	LOCKNUT
6	6	MS27039-0819	SCREW
7	12	NAS1149FN832P	WASHER
8	A/R	LOCTITE 598	RTV SEALANT



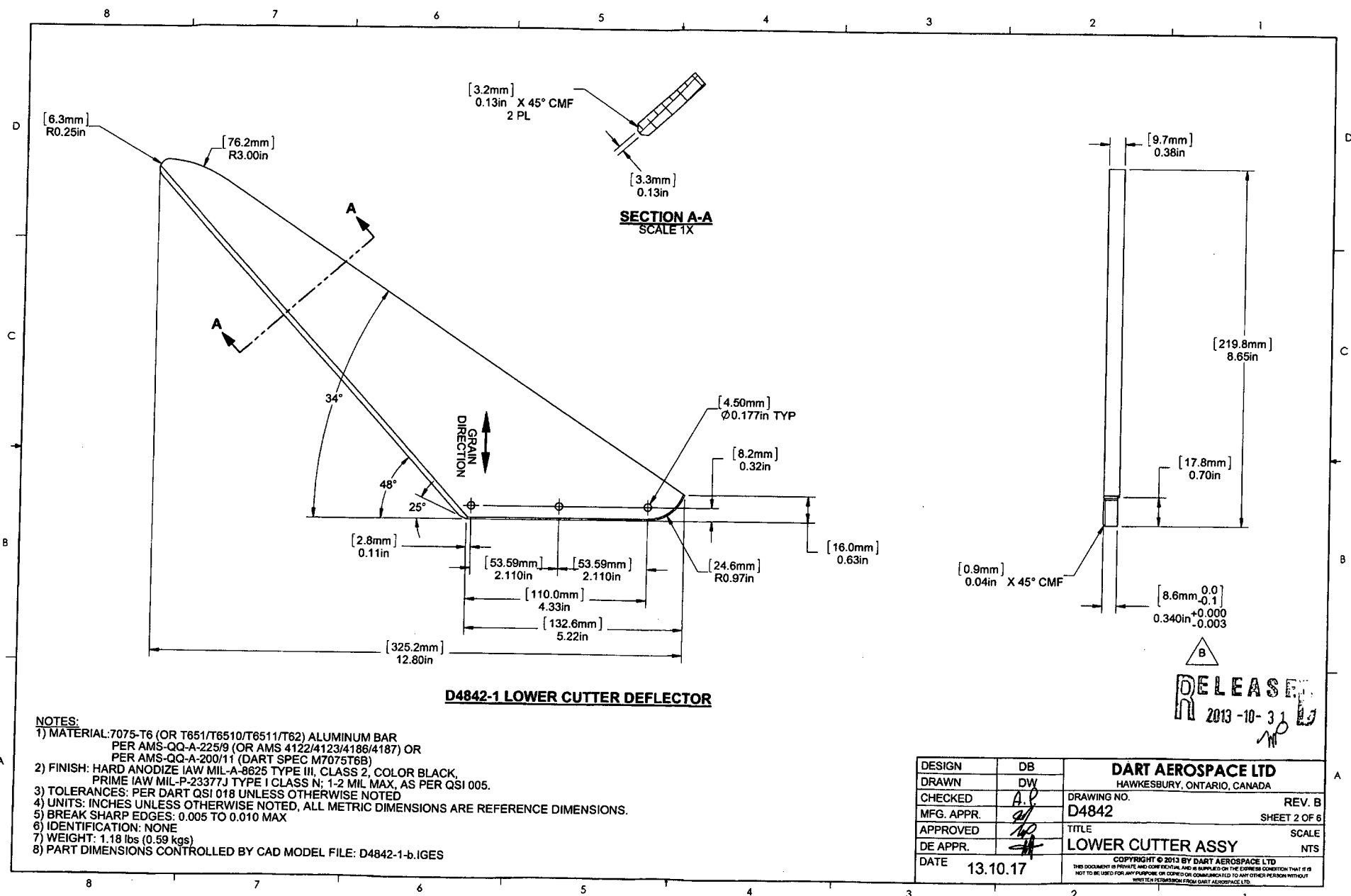
D4842-041 LOWER CUTTER ASSEMBLY

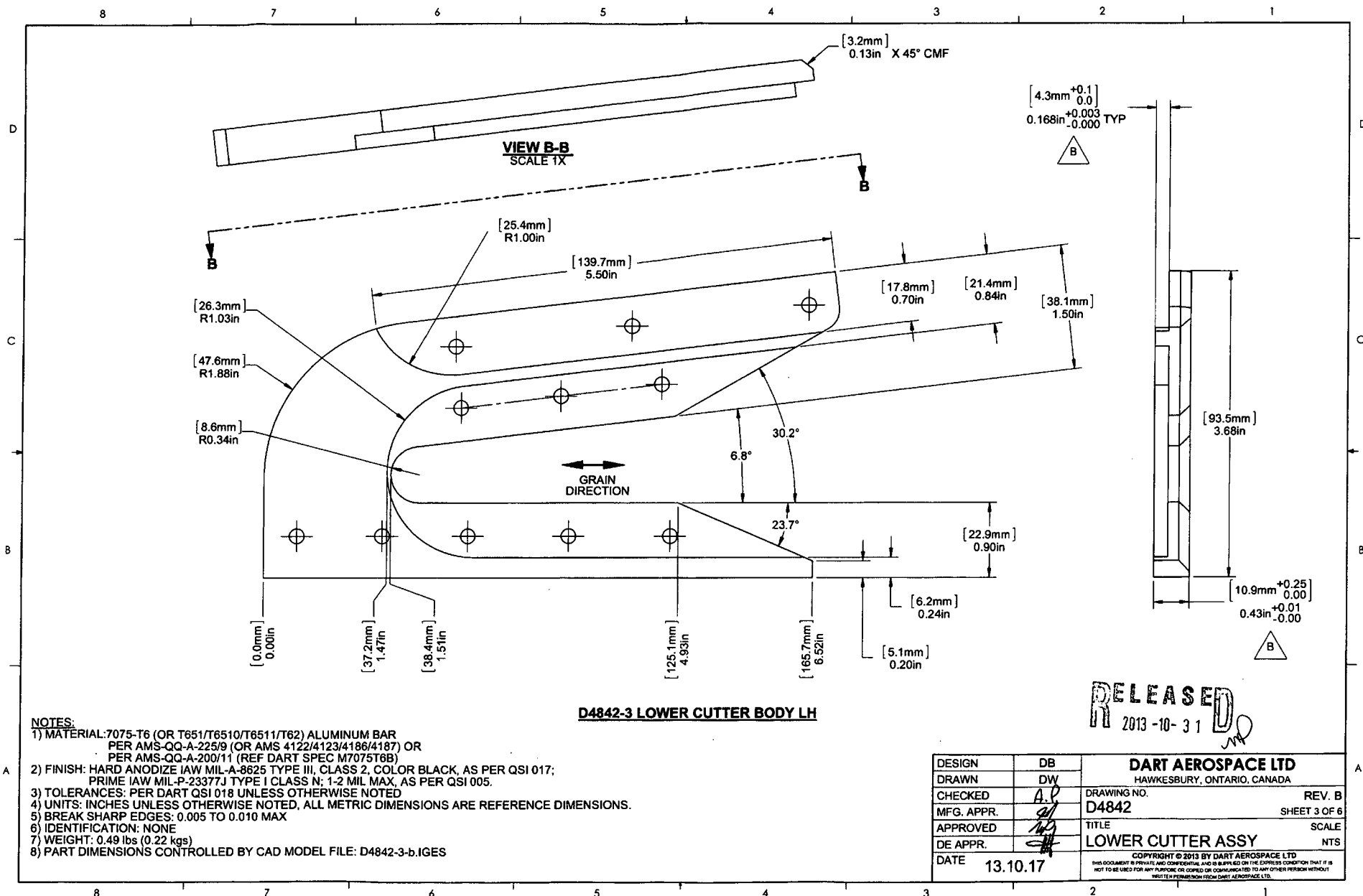
NOTES:

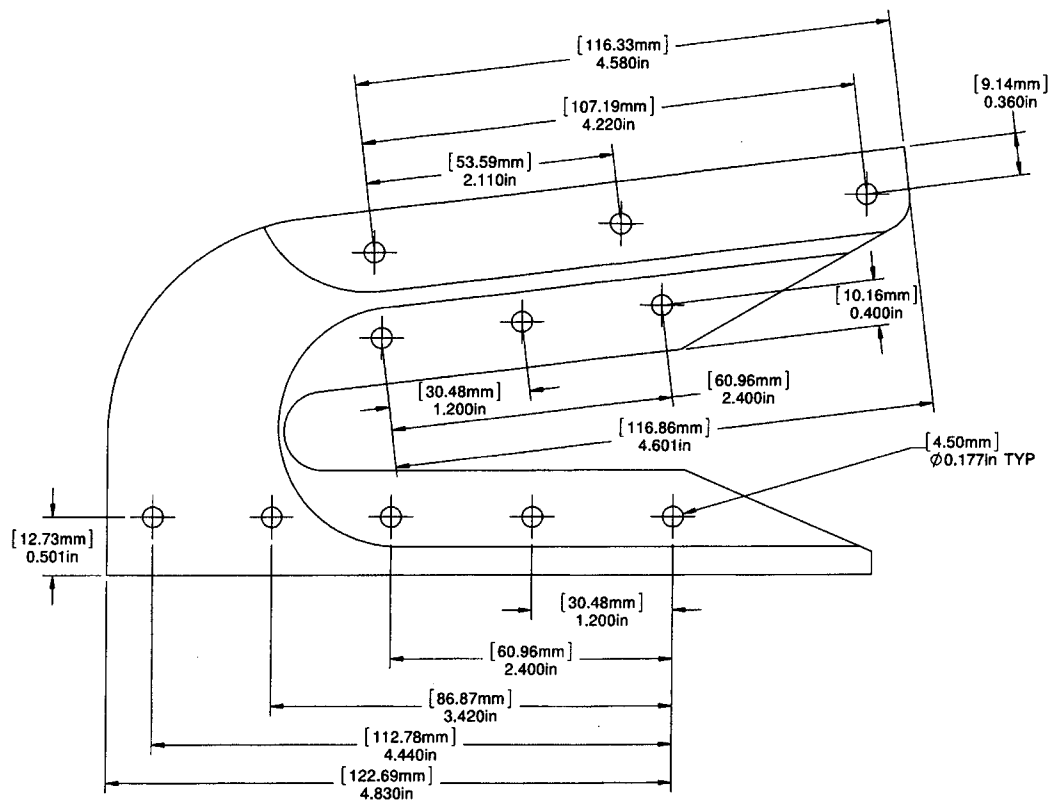
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4842-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 2.79 lbs (1.26 KGS)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

RELEASED
20150925
SH 137358

B	CORRECT TOLERANCES (ZN B1-2) (ZN B1-3, D2-3)	DW	13.10.17
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4842 TITLE LOWER CUTTER ASSY SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DW		
CHECKED	A.P.		
MFG. APPR.	21		
APPROVED	21		
DE APPR.	21	REV. B SHEET 1 OF 6	
DATE	13.10.17		



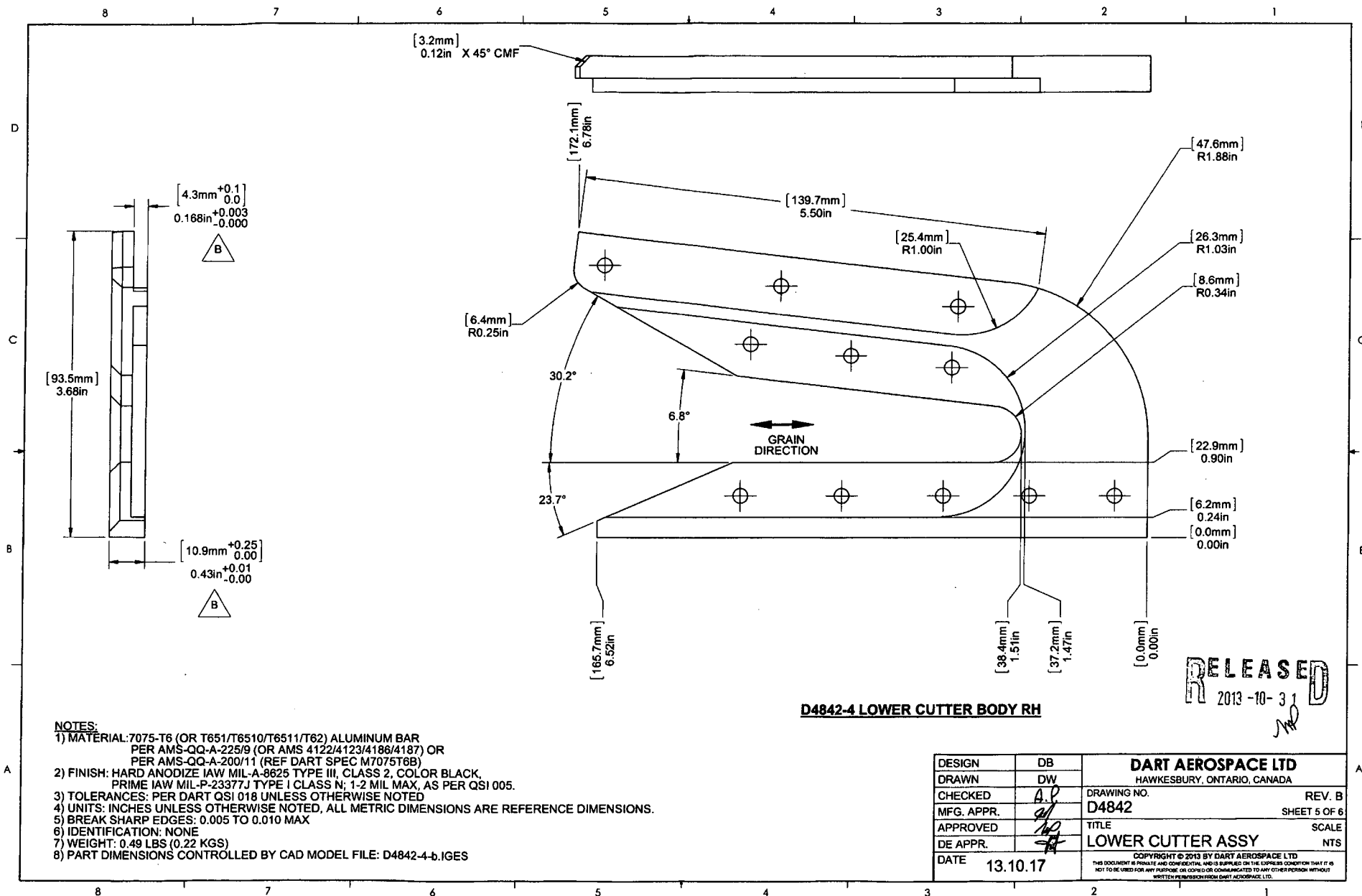


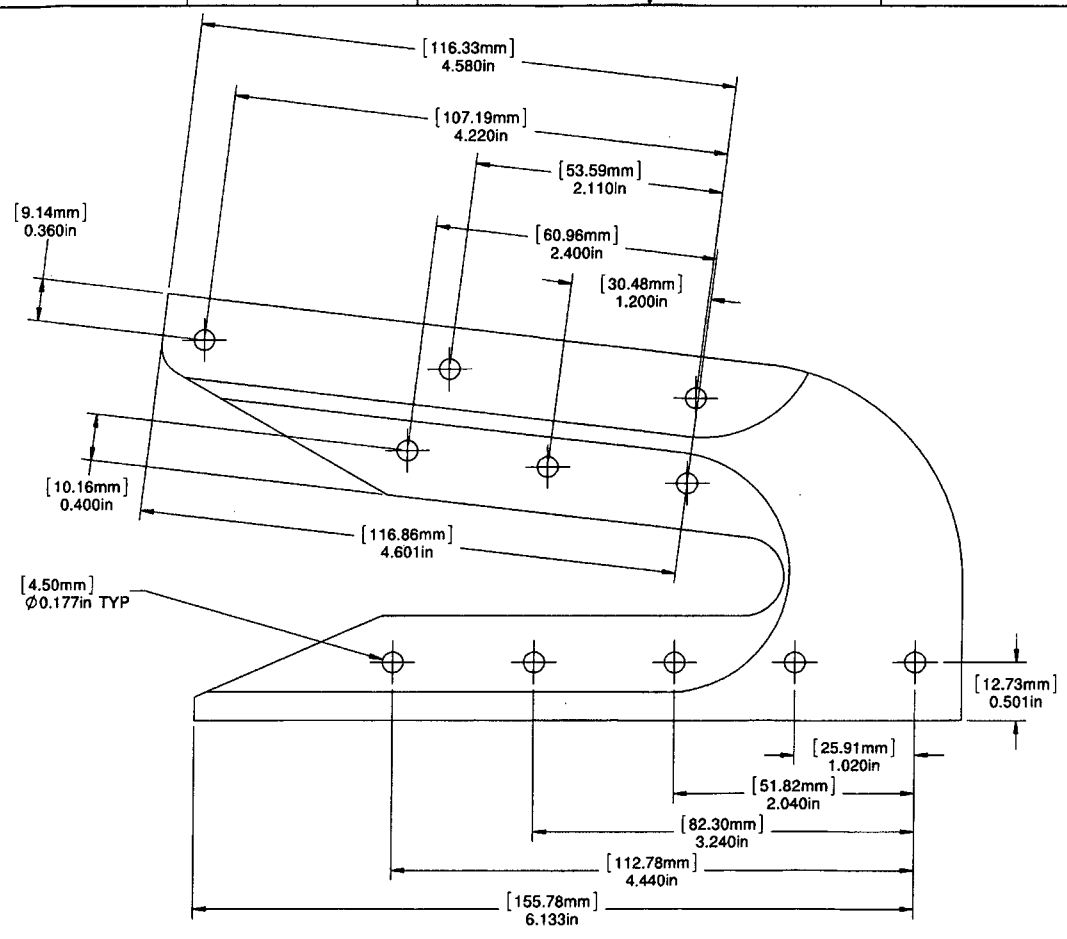


D4842-3 LOWER CUTTER BODY LH
(AUXILIARY VIEW)

RELEASE
2013-10-31

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AP	DRAWING NO. D4842	REV. B
MFG. APPR.	AP		SHEET 4 OF 6
APPROVED	AP	TITLE LOWER CUTTER ASSY	SCALE NTS
DE APPR.	AP	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.10.17		





D4842-4 LOWER CUTTER BODY RH
(AUXILLIARY VIEW)

RELEASE
2013-10-31

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	A.P.	DRAWING NO. D4842	REV. B
MFG. APPR.	[Signature]	SHEET 6 OF 6	
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	LOWER CUTTER ASSY	NTS
DATE	13.10.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	